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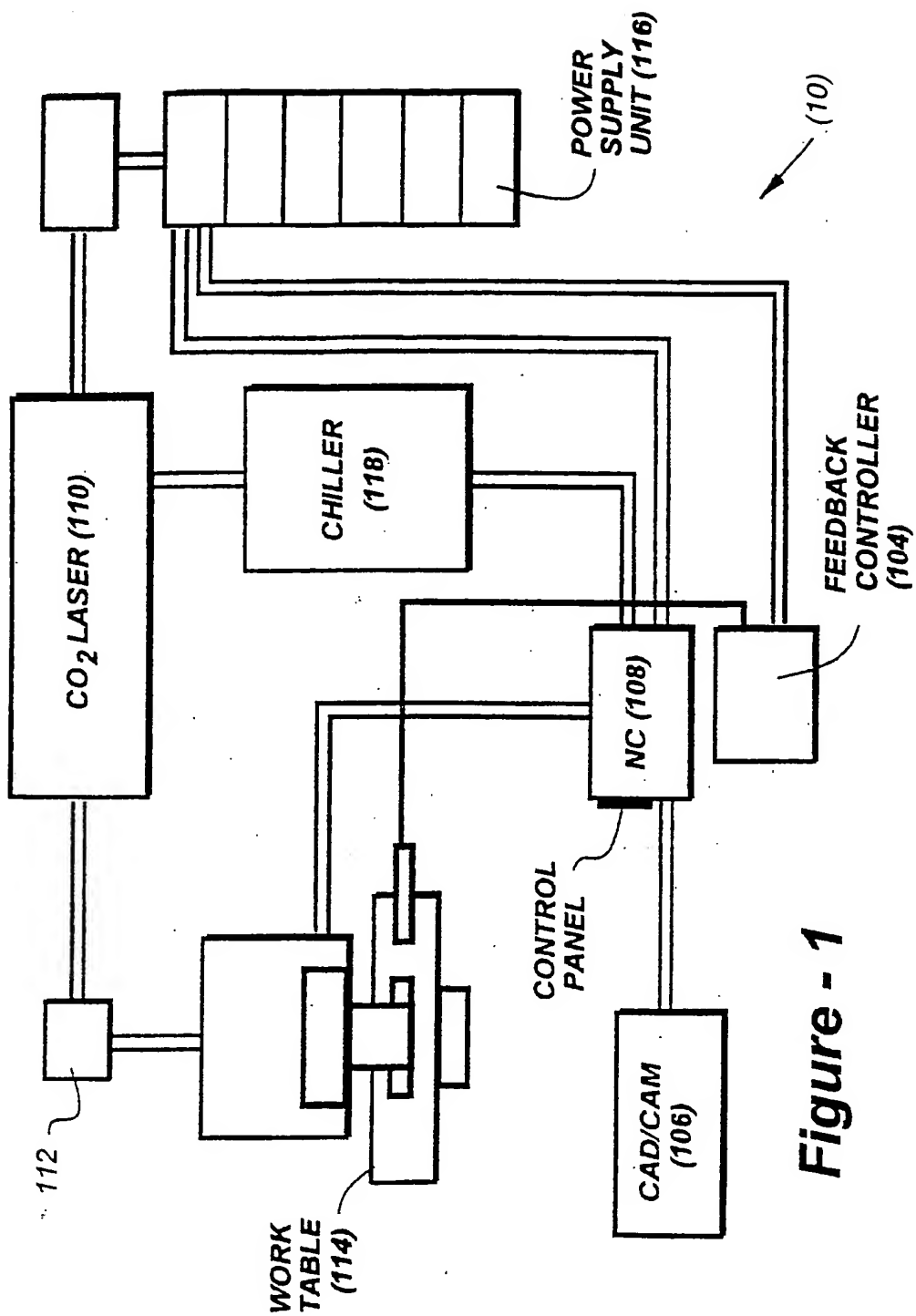


Figure - 1

Figure - 2

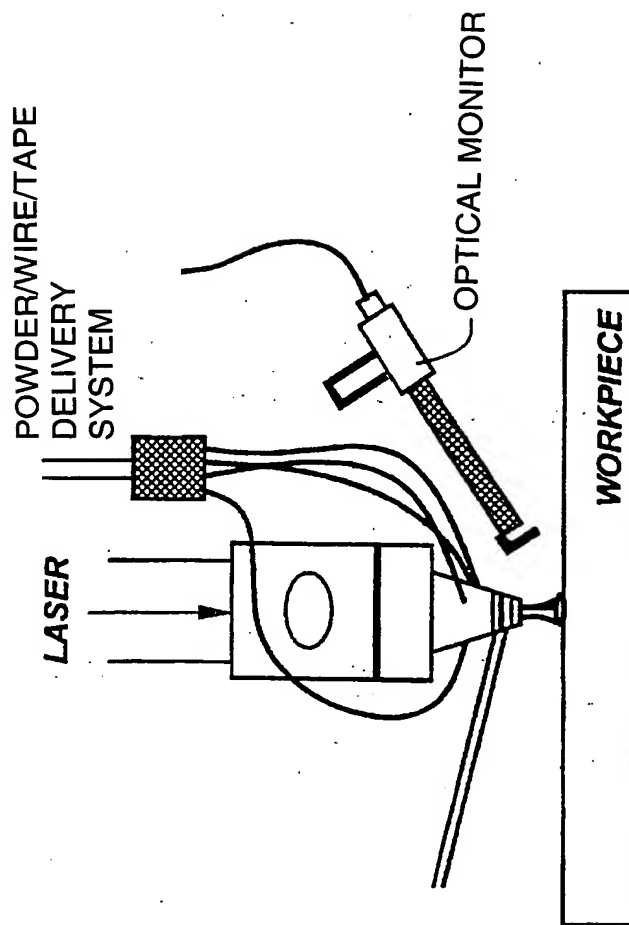




FIGURE 3

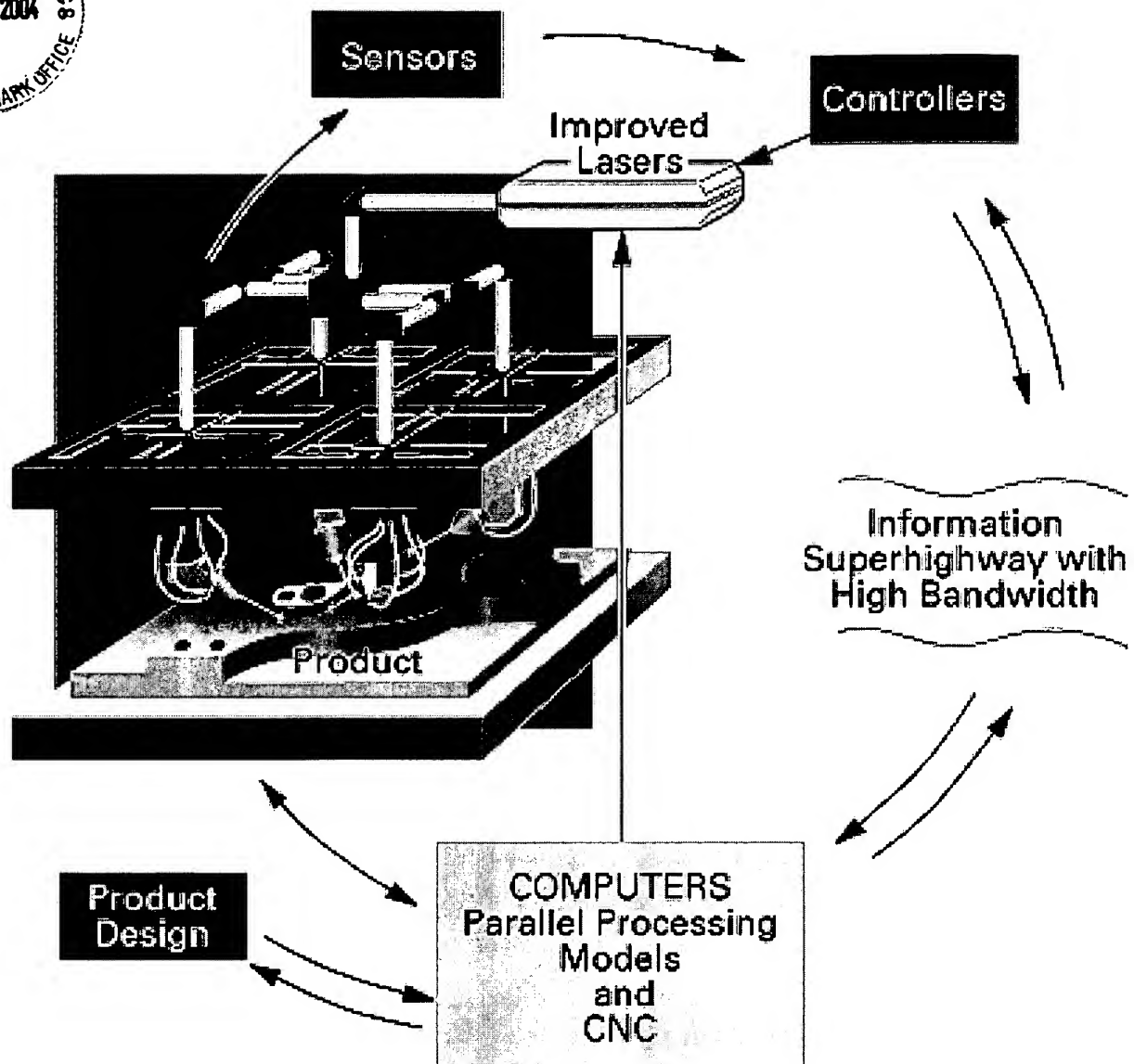


FIGURE 4

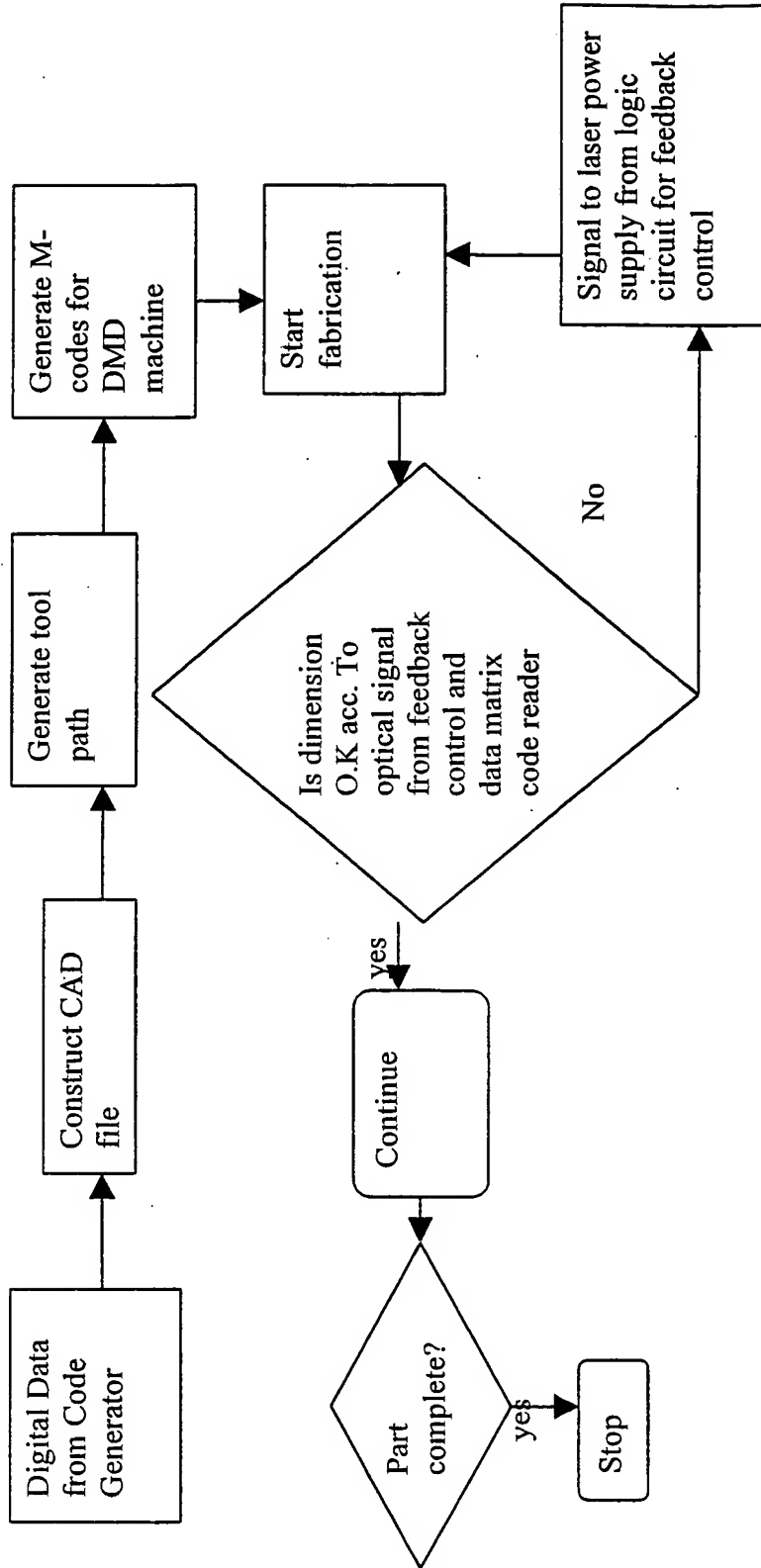


FIGURE 5

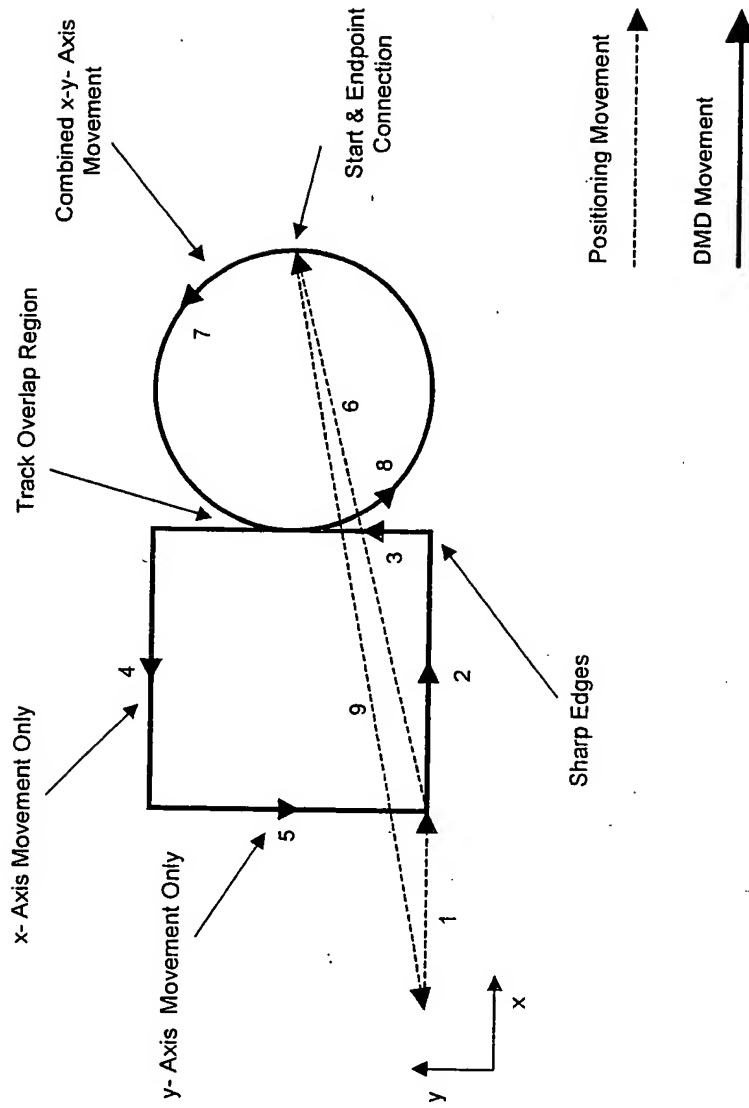
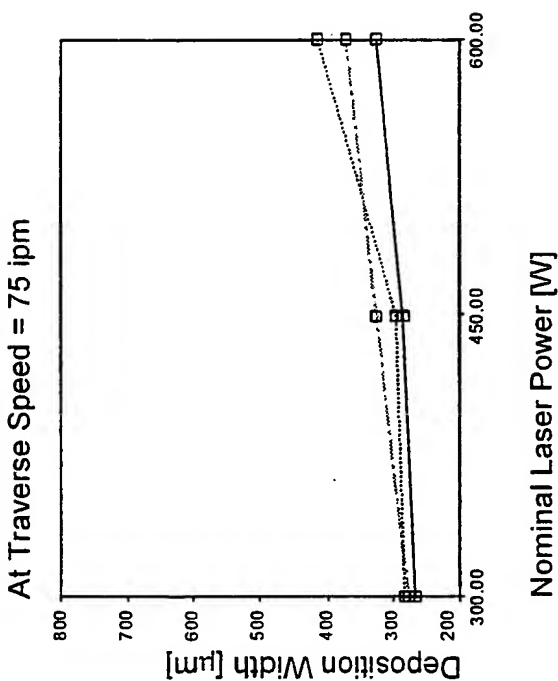
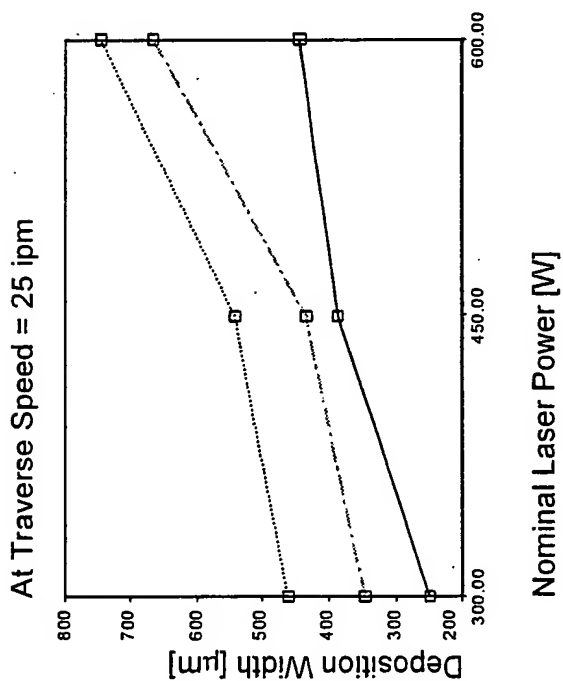
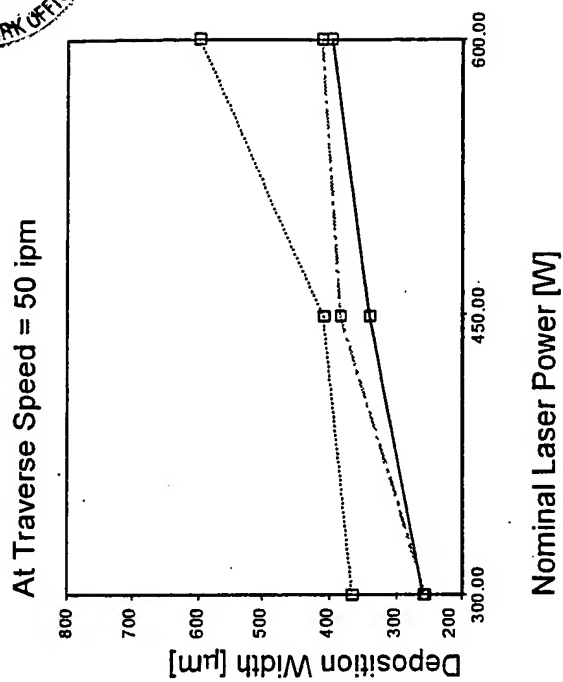


FIGURE 6



Powder Feed Rate [g/30s]

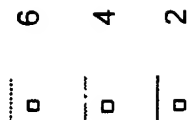
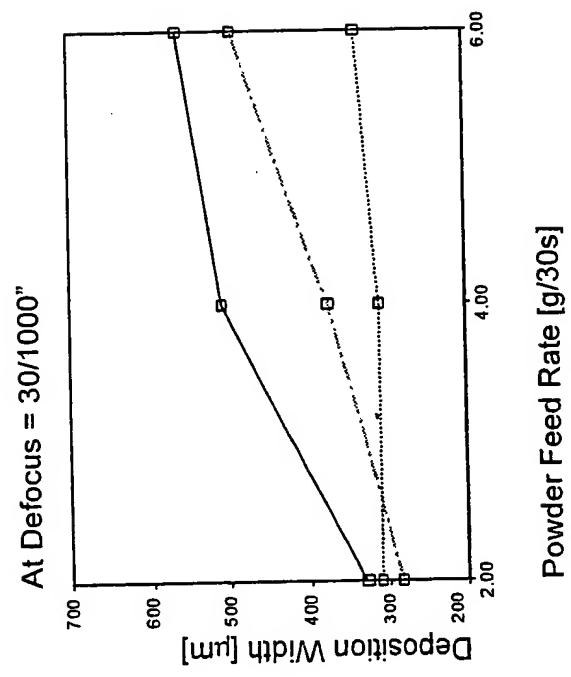
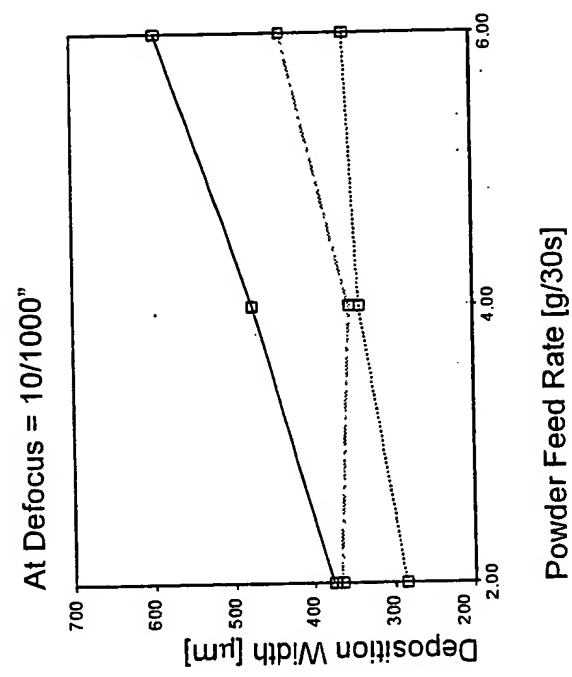
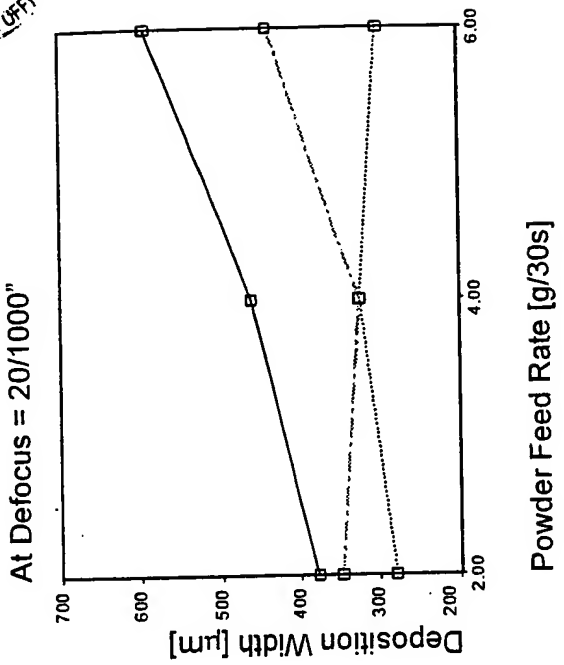


FIGURE 7

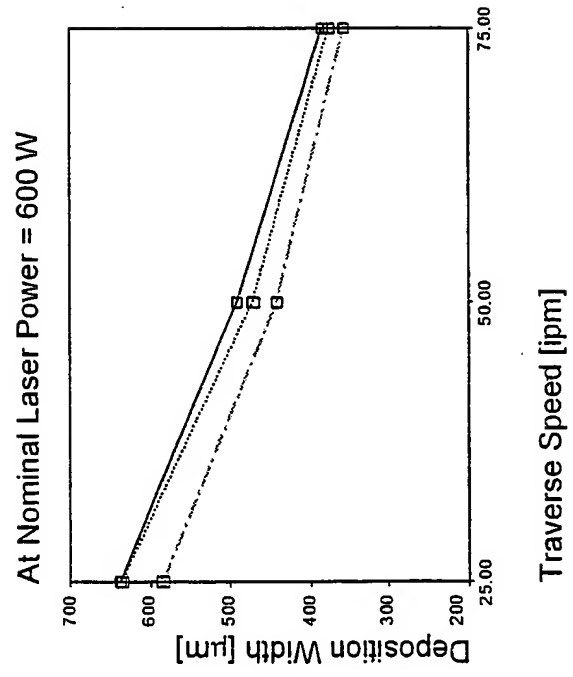
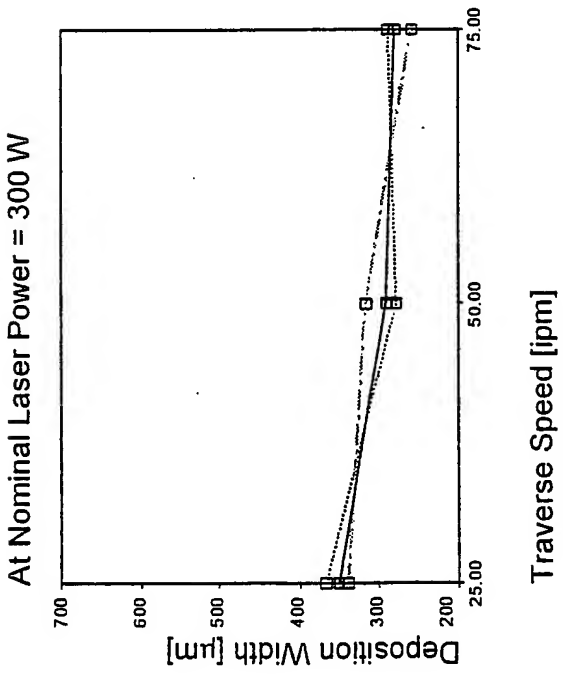
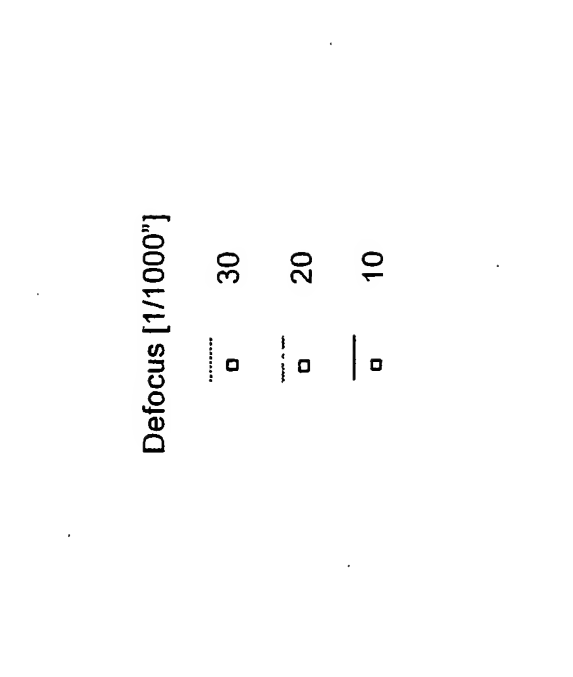
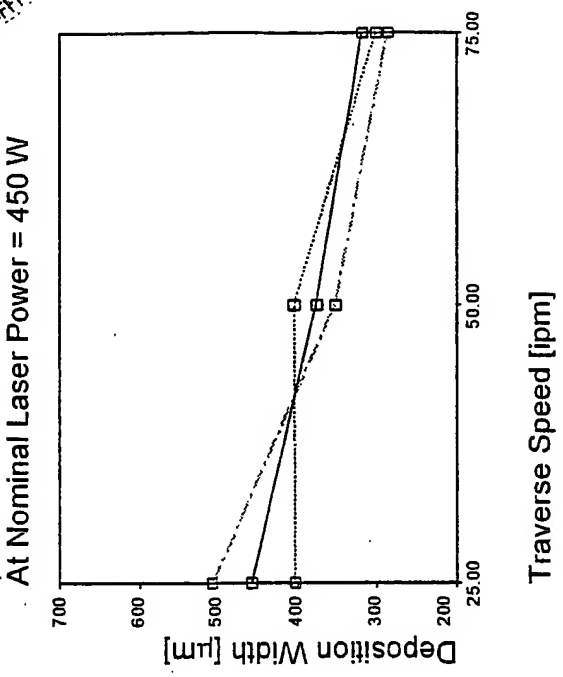
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MAR 29 2004



Traverse Speed [ipm]

□	75
□	50
□	25

FIGURE 8



Defocus [1/1000"]

□ 30

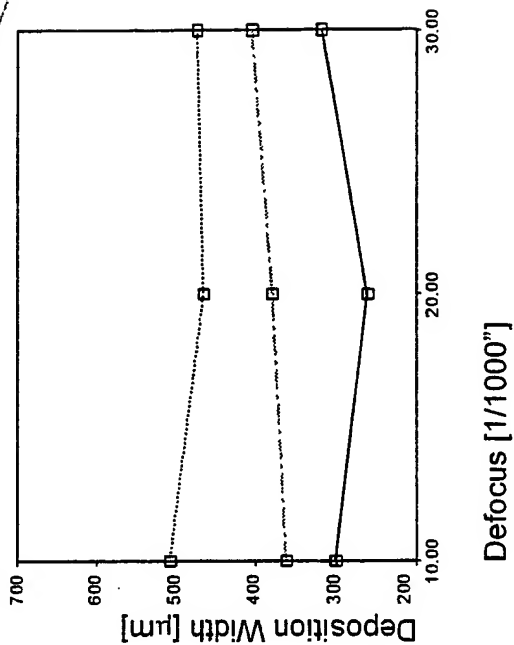
□ 20

□ 10

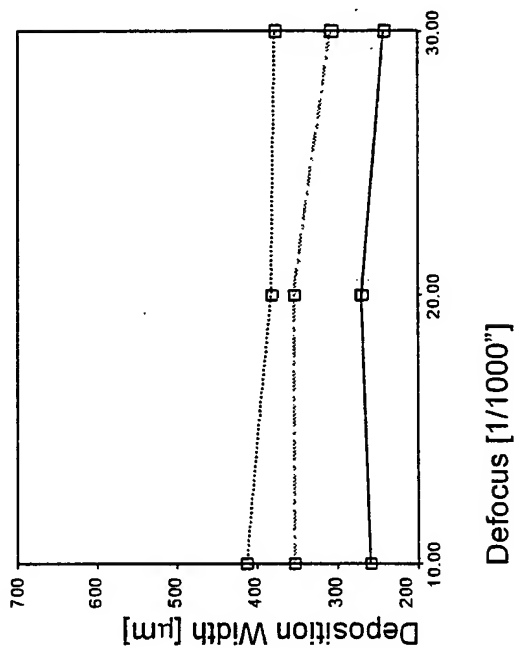
FIGURE 9



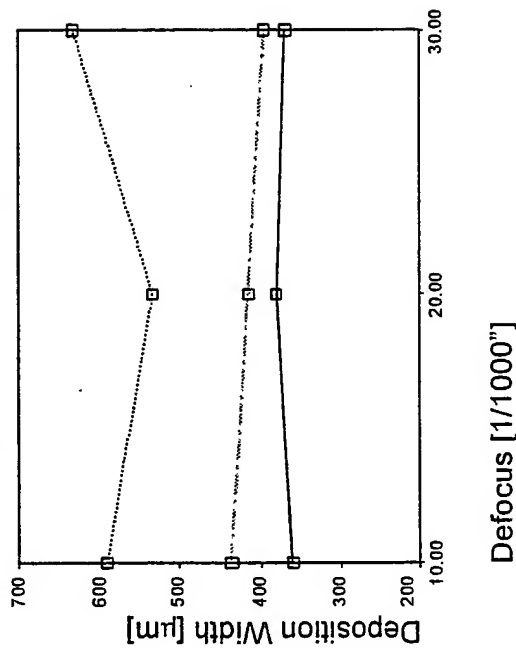
At Powder Feed Rate = 4 g/30s



At Powder Feed Rate = 2 g/30s



At Powder Feed Rate = 6 g/30s



Nominal Laser Power [W]

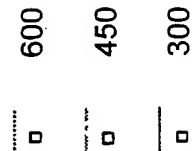
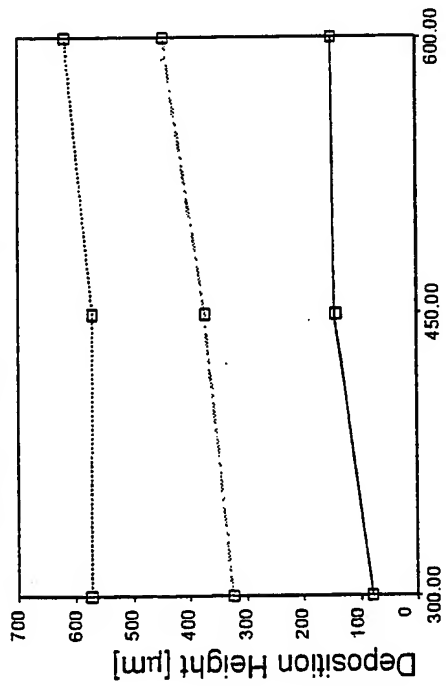


FIGURE 10

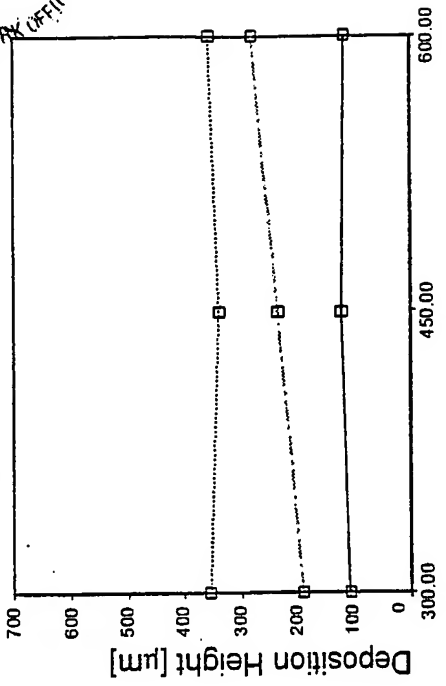


At Traverse Speed = 25 ipm



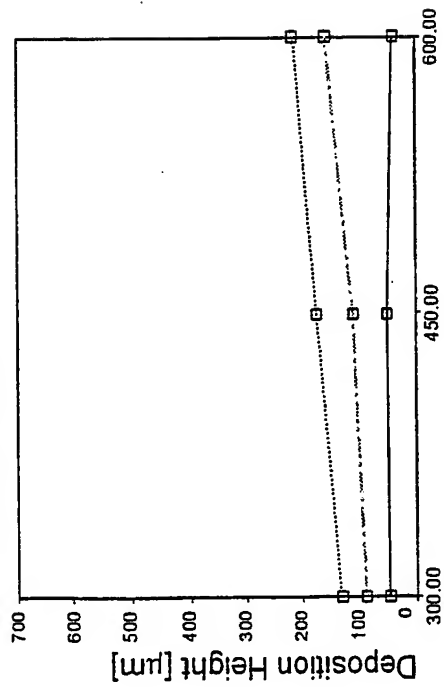
Nominal Laser Power [W]

At Traverse Speed = 50 ipm



Nominal Laser Power [W]

At Traverse Speed = 75 ipm



Nominal Laser Power [W]

Powder Feed Rate

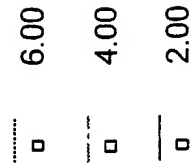
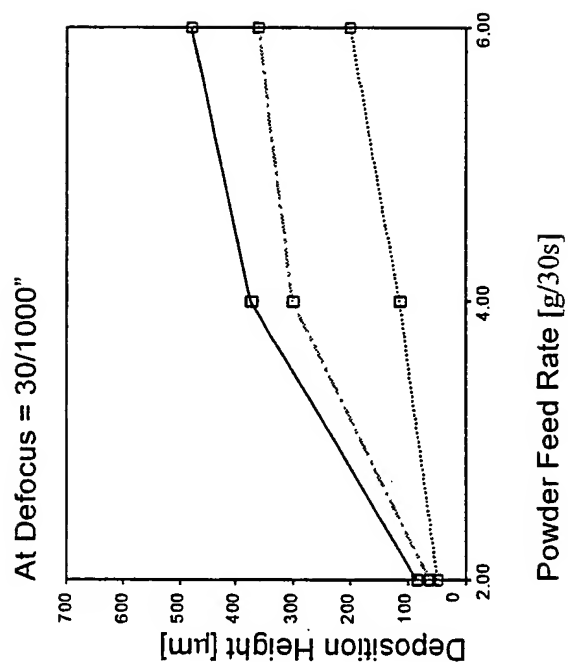
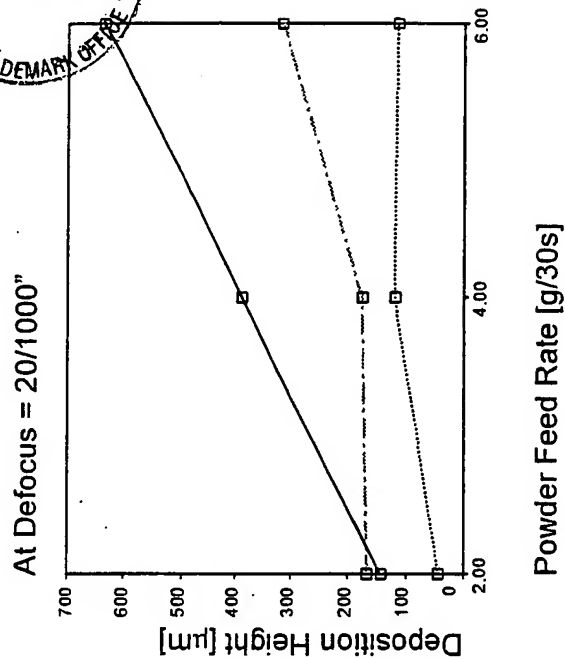
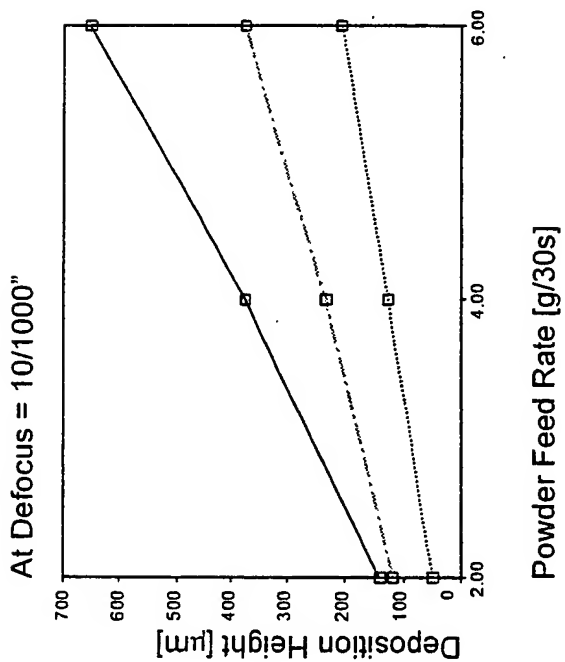
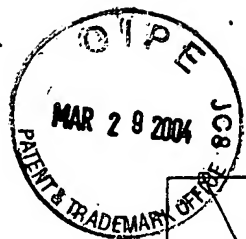


FIGURE 11



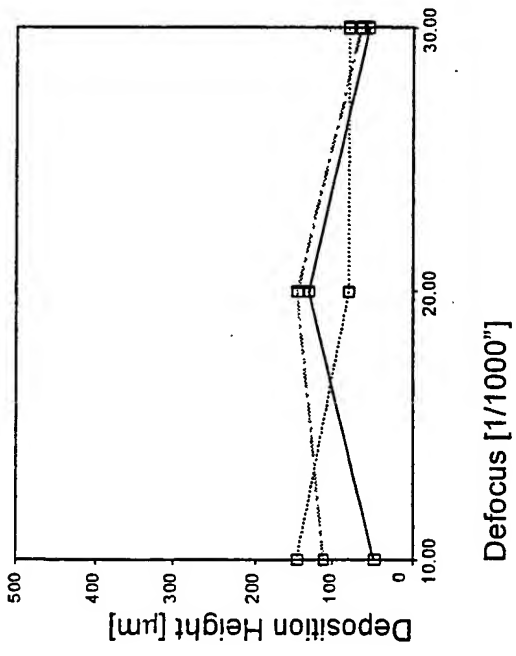
Traverse Speed [ipm]

.....	75
- . - . - .	50
_____	25

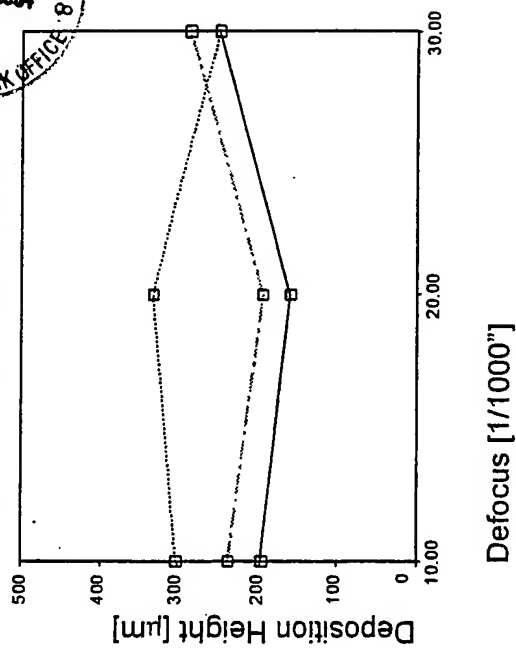
FIGURE 12



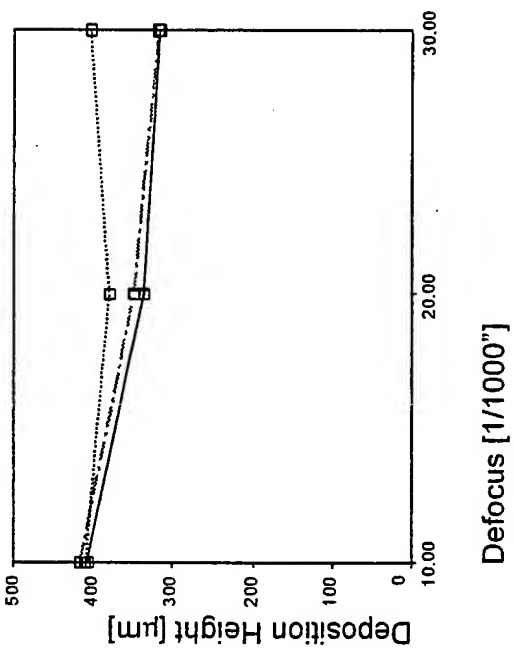
At Powder Feed Rate = 2 g/30s



At Powder Feed Rate = 4 g/30s



At Powder Feed Rate = 6 g/30s



Nominal Laser Power [W]

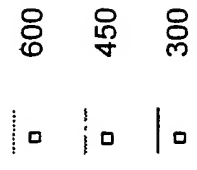


FIGURE 13

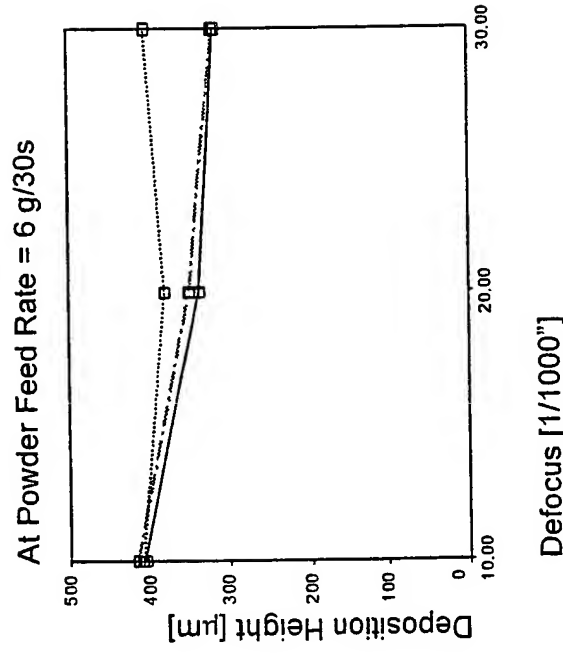
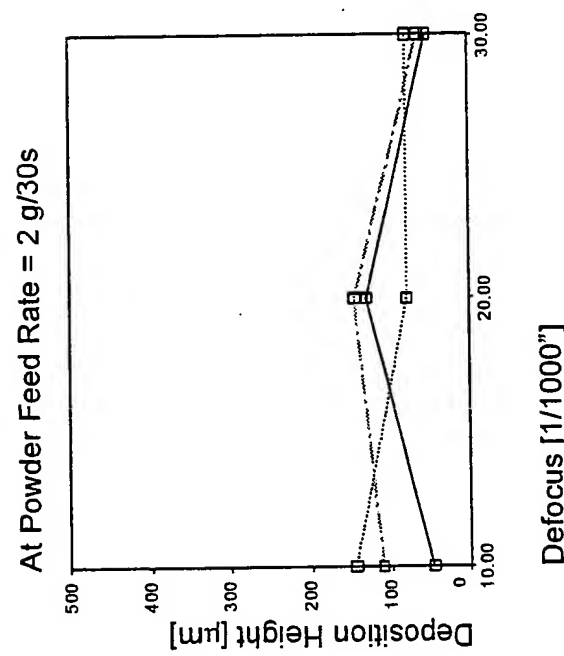
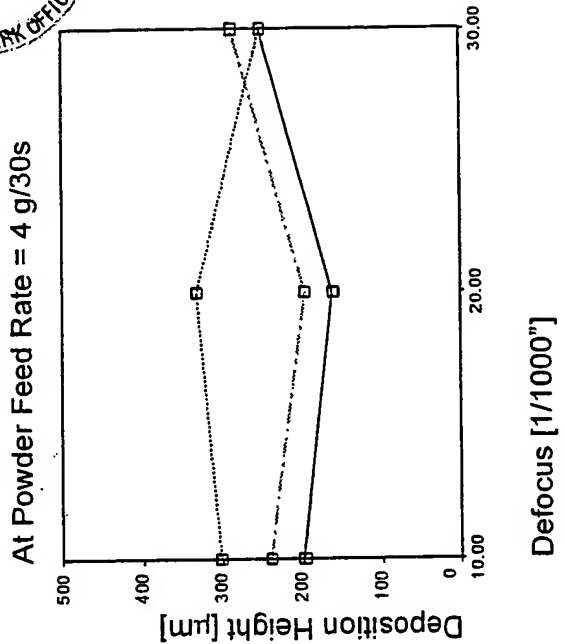
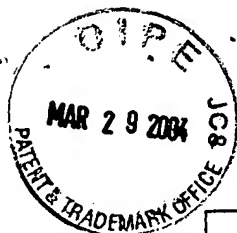


FIGURE 14